

S180313



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3885-1

Job Sheet 192941



Part No: D3885-1

Job Qty: 6 pcs

Part Name: Standard Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/4/19

Job Tracking No:

Due Date: 5/23/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
108	Purchasing	6 pcs	5/23/19		0.00	0.00	Purchasing - 1		AT 14/05/10
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	6 pcs	5/23/19		0.00	0.00	Packaging 2 - 1 - B4B		AT 14/05/10
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		

Plex 4/4/19 11:07 AM dart.Lussier.Patrick

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	6 pcs	5/23/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
130 Handfinish - 1-1 Chemical-B4B	6 pcs	5/23/19	0.00	1.86	Handfinish - 1 - 1 - B4B	9-89
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	DR 19/05/14
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	6 pcs	5/23/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	

				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
150	Packaging 3-1 - Stock - B4B	6 pcs	5/23/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
160	QC 21 - SA	6 pcs	5/23/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

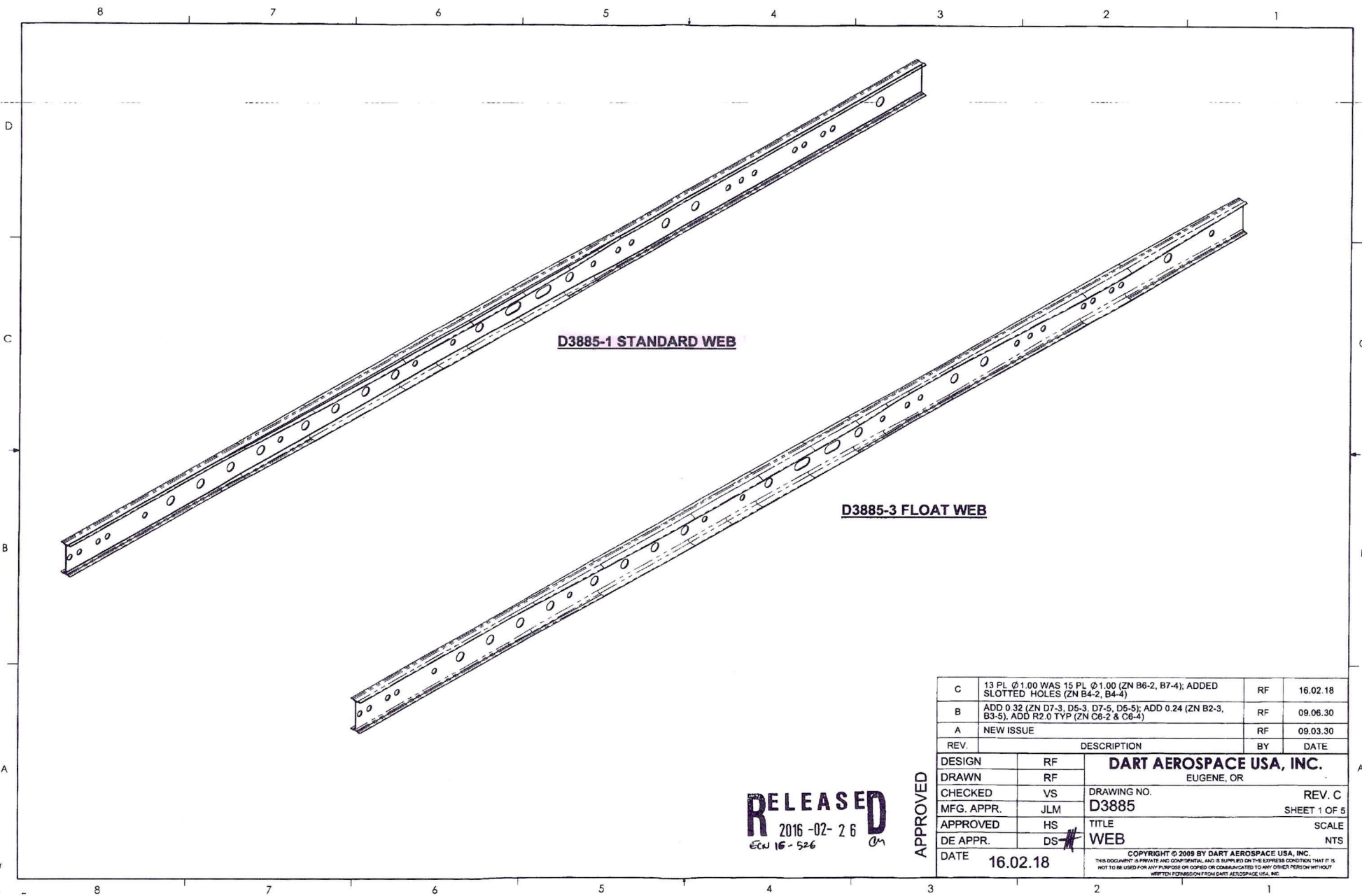
Part Op **108** - Purchasing Issue P/O: 043101 Supplier: WEJAY Machine as per Dwg D3885
 Descriptions: **110** - (Receive & Inspect for Damage & Mat'l Certs)
120 - (QC6- All purchased or subcontracted products)
130 - (Chemical Conversion Coat per QSI005 4.1)
140 - (QC7-Inspect Chemical Conversion Coat)
150 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002
160 - (QC21- Final Inspection - Work Order Release)

xb plus

04 APR 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3882-1-130	Extrusion "I" Beam	6 pcs (1 ea)	108-Purchasing	5180312
D3885-1P	Standard Web	6 pcs (1 ea)	108-Purchasing	5180293
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
108-Purchasing	D3882-1-130	6	88	0
	D3885-1P	6	0	0
Part Specifications				
Specifications could not be found.				

Plex 4/4/19 11:07 AM dart.Lussier.Patrick



C	13 PL Ø1.00 WAS 15 PL Ø1.00 (ZN B6-2, B7-4); ADDED SLOTTED HOLES (ZN B4-2, B4-4)	RF	16.02.18
B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5); ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-02-26
ETW 16-526

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043101



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO043101
PO Date: 4/4/19
Due Date: 5/23/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1 <i>Ar</i>	192940	D3885-1P			Standard Web : Various STC's	Firmed	-	4/11/19	6 pcs ✓	0 pcs 6x	6 pcs <i>Ar</i> 19/04/19	\$520.00/pcs	\$3,120.00
2	192941	D3885-1P			Standard Web : Various STC's	Firmed	-	5/23/19	6 pcs ✓	0 pcs 6x	6 pcs <i>Ar</i> 19/05/19	\$520.00/pcs	\$3,120.00
Grand Total:													\$6,240.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 4/4/19 1:34 PM dart.Lussier.Patrick

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: May 7, 2019		
	P.O.# PO 043101		
	WEJAY JOB# 39494		
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-1P 'Standard Web' w/o 192941	6	Machined supplied extrusions complete per drawing req'ts	D3885 sheets 2-3 / rev. C
Note: 1) Material supplied by Dart Aerospace.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 39494A

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO 043101

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR: Paul Roosen

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
--

N.C.R.#
--

DATE: May 1, 2019

INSTRUCTIONS, COMMENTS: 1st ARTICLE INSPECTION / FINAL INSPECTION

Ref. PO W/O# 192941

Paul Roosen
WMP 03

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	Hole, Ø .63"	18 places	+.008/-.001		Ø .633 typ.	1	Accepted
2	Hole, Ø 1.00"	13 places	+.010/-.001		Ø 1.003 typ.	1	Accepted
3	Slot, R 0.50	2 places	+.010/-.001		R .500 typ.	1	Accepted
4	5.51"		± .03		5.5115	1	Accepted
5	11.86"		± .03		11.8525	1	Accepted
6	13.11"		± .03		13.101	1	Accepted
7	15.61"		± .03		15.600	1	Accepted
8	16.86"		± .03		16.849	1	Accepted
9	22.29"		± .03		22.285	1	Accepted
10	24.04"		± .03		24.0345	1	Accepted
11	25.79"		± .03		25.778	1	Accepted
12	30.14"		± .03		30.12	1	Accepted
13	34.14"		± .03		34.122	1	Accepted
14	38.67"		± .03		38.655	1	Accepted
15	40.42"		± .03		40.407	1	Accepted
16	43.71"		± .03		43.7005	1	Accepted
17	46.91"		± .03		46.899	1	Accepted
18	49.91"		± .03		49.902	1	Accepted
19	50.91"		± .03		50.899	1	Accepted
20	53.91"		± .03		53.901	1	Accepted
21	54.91"		± .03		54.903	1	Accepted
22	58.91"		± .03		58.902	1	Accepted
23	62.43"		± .03		62.427	1	Accepted
24	67.43"		± .03		67.4265	1	Accepted
25	70.10"		± .03		70.09	1	Accepted
26	74.10"		± .03		74.092	1	Accepted
27	78.10"		± .03		78.094	1	Accepted
28	82.10"		± .03		82.097	1	Accepted
29	85.43"		± .03		85.433	1	Accepted

INSPECTION / TEST REPORT						JOB No.	
						PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHI/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	88.01"		± .03		88.013	1	Accepted
31	92.01"		± .03		92.014	1	Accepted
32	96.01"		± .03		96.0124	1	Accepted
33	100.01"		± .03		100.014	1	Accepted
34	103.43"		± .03		103.432	1	Accepted
35	108.42"		± .03		108.421	1	Accepted
36	109.67"		± .03		109.6695	1	Accepted
37	112.17"		± .03		112.168	1	Accepted
38	113.42"		± .03		113.417	1	Accepted
39	113.92" o.a.		± .03		113.9155	1	Accepted
40	1.25" TYP	Section A-A, J-J	± .03		1.264	1	Accepted
41	R.03" TYP		± .03		Passed	1	Accepted
42	R.02" TYP		± .03		Passed	1	Accepted
43	3.358"		+ .010/- .030		3.360	1	Accepted
44	R.13" TYP		± .03		Passed	1	Accepted
45	.32" TYP		± .03		.318	1	Accepted
46	3.466"		+ .010/- .030		3.472	1	Accepted
47	R.13" TYP		± .03		Passed	1	Accepted
48	.080 TYP, REF		± .03		.070	1	Accepted
49	1.37" TYP	Section B-B	± .03		1.385	1	Accepted
50	R.03" TYP		± .03		Passed	1	Accepted
51	R.02" TYP		± .03		Passed	1	Accepted
52	3.358"		+ .010/- .030		3.352	1	Accepted
53	R.25" TYP		± .03		Passed	1	Accepted
54	.32" TYP		± .03		.320	1	Accepted
55	R.25" TYP		± .03		Passed	1	Accepted
56	3.428"		+ .010/- .030		3.430	1	Accepted
57	1.80" TYP	Section C-C	± .03		1.808	1	Accepted
58	R.03" TYP		± .03		Passed	1	Accepted
59	R.02" TYP		± .03		Passed	1	Accepted
60	3.246"		+ .010/- .030		3.246	1	Accepted
61	R.25" TYP		± .03		Passed	1	Accepted
62	2.00" TYP	Section D-D	± .03		1.986	1	Accepted
63	R.03" TYP		± .03		Passed	1	Accepted
64	R.02" TYP		± .03		Passed	1	Accepted

INSPECTION / TEST REPORT						JOB No.	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

65	3.095"		+ .010/- .030		3.0985	1	Accepted
66	R.25" TYP		± .03		Passed	1	Accepted
67	2.00" TYP	Section E-E, F-F	± .03		1.987	1	Accepted
68	R.03" TYP		± .03		Passed	1	Accepted
69	R.02" TYP		± .03		Passed	1	Accepted
70	3.026"	(stock dim)	+ .010/- .030		3.030	1	Accepted
71	R.25" TYP		± .03		Passed	1	Accepted
72	1.96"	Section G-G	± .03		1.964	1	Accepted
73	R.03" TYP		± .03		Passed	1	Accepted
74	R.02" TYP		± .03		Passed	1	Accepted
75	3.157		+ .010/- .030		3.160	1	Accepted
76	R.25" TYP		± .03		Passed	1	Accepted
77	1.82"	Section H-H	± .03		1.822	1	Accepted
78	R.03" TYP		± .03		Passed	1	Accepted
79	R.02" TYP		± .03		Passed	1	Accepted
80	3.238"		+ .010/- .030		3.242	1	Accepted
81	R.25" TYP		± .03		Passed	1	Accepted
82	1.48"	Section I-I	± .03		1.485	1	Accepted
83	R.03" TYP		± .03		Passed	1	Accepted
84	R.02" TYP		± .03		Passed	1	Accepted
85	3.358		+ .010/- .030		3.360	1	Accepted
86	R.25" TYP		± .03		Passed	1	Accepted
87	3.396"		+ .010/- .030		3.396	1	Accepted
88	R.25" TYP		± .03		Passed	1	Accepted

Patrick Lussier

From: ejansen@wejay.com
Sent: Friday, May 10, 2019 1:28 PM
To: Patrick Lussier
Subject: Re: PO043101 Material used ?

Patrick. The 6 you should have received today would have came from batch S046247 which is the latest shipment of 68 pcs you sent us.

Thanks

Ed

From: [Patrick Lussier](#)
Sent: Friday, May 10, 2019 12:55 PM
To: [Scott Dennis](#) ; [ejansen@wejay.com](#)
Subject: PO043101 Material used ?

Hi Scott / Ed

On po043101 could you please advise which Dart batch # you used for the production of the parts

See option below

Thanks

Op No	Operation	Serial No / Ship Unit	Containers	Job	Change Number	Quantity	Weight	Location	Container
Part No: D3882-1-130 Revision: Extrusion 1									
140	QC 21 - SA	<u>F162690</u>	1			13	0	WEJAY	
		<u>S046247</u>	1	<u>169462</u>		68	0	WEJAY	Bin
		<u>S137559</u>	1			1	0	HALL	Bin

Patrick Lussier
Senior Buyer

DART AEROSPACE
T 1 613 632-5200 ext : 276
F 1 613 632-1053
E plussier@dartaero.com
1 800 556- 4166
www.dartaerospace.com



MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D3885-1
DATE: _____

PO / BATCH NO.: P0043101/S180313

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 6x
QUANTITY INSPECTED: 6x
QUANTITY REJECTED: 0

THICKNESS ORDERED: .1"
THICKNESS RECEIVED: .1"
SHEET SIZE ORDERED: -
SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	<u>D3885-1</u>
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	<u>P0043101</u>
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>Um</u>	<u>61</u> 9-89	SIGNED OFF BY: _____	
DATE: <u>MAY 10 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in